



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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DSK076

Job Sheet 198390



Part No: DSK076

Job Qty: 6 pcs

Part Name: D2891-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/26/19

Job Tracking No:

Due Date: 7/31/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
100	Doosan - 1	6 pcs	7/31/19	0.06 4.03	Doosan - 1		
110	QC 2	6 pcs	7/31/19	0.00 0.00	QC 2 - 1		
					QC 2 - 12		
					QC 2 - 14		
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23		
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
120	QC 8	6 pcs	7/31/19	0.00 0.00	QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		

DAS
5
9-89

DAS
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9-89



Container No: S200832



Part: DSK076

Job No: 198390

Serial No/Batch: S200832

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 07/26/19

Plex 7/26/19 8:29 AM Dart.Renwick.Jennifer

				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS
				QC 8 - 52	52
				QC 8 - 23	9-89
				QC 8 - 57	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	DAS
				Packaging 3 - 31 - B4B	52
				Packaging 3 - 32 - B4B	9-89
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130	Packaging 3-1 - Stock - B4B	6 pcs	7/31/19	0.00 0.00	
140	QC 21 - SA	6 pcs	7/31/19	0.00 0.00	
					QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Turn blank for as per Folio FA046 DT8671 Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____ LOCATION: MAT060) 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6104-003	Round Billet, 17-4	6 pcs (1 ea)	100-Doosan - 1		

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-003	6	21	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 198390
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

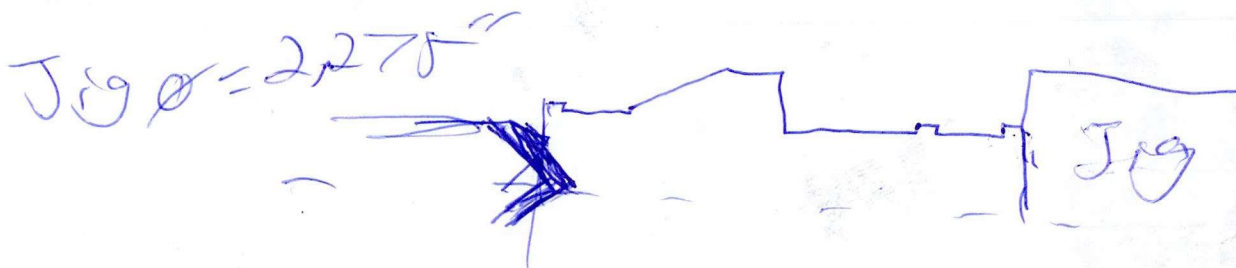
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279	DT 8671	2.278	2.279	2.285	2.278	2.278
B	3.702	3.722	Caliper	3.708	3.709	3.710	3.710	3.711
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.729				
E	0.090	0.110		.097				
F	2.464	2.484		2.476				
G	2.029	2.049		2.038				
H	2.964	2.984		2.974				
I	0.913	0.933		.922				
J	0.022	0.042		.032				
K	0.090	0.110		.098	.0985	.099	.0985	.0995
L								
M								
N								
O								
P								

Measured by: DC	Date: 19/07/26
Audited by: DAS 52	Date: 19/08/17
Prototype Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DART AEROSPACE LTD		Work Order: 198390
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278				
B	3.702	3.722		3.702				
C	2.564	2.584		2.574				
D	0.718	0.738		0.729				
E	0.090	0.110		0.097				
F	2.464	2.484		2.476				
G	2.029	2.049		2.037				
H	2.964	2.984		2.974				
I	0.913	0.933		0.920				
J	0.022	0.042		0.030				
K	0.090	0.110		0.098				
L								
M								
N								
O								
P								

Measured by: DC	Date: 19/07/20
Audited by: DAS 52	Date: 19/08/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	